

Date: Friday, 08/05/2009 7:53:12 AM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BAR  
 Job Number : 47816  
 Estimate Number : 13885  
 P.O. Number :  
 This Issue : 08/05/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 09-05-07  
 Comment : Est Rev:A 09.04.24 new issue EC verified by:DD

Part Number : D39015  
 Drawing Number : D3901 PREL  
 Project Number : N/A  
 Drawing Revision : PREL  
 Material :  
 Due Date : 15/05/2009 Qty: 2 Um: Each

## Additional Product

**PRELIMINARY ISSUE** 09.05.08

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0500X2500 304 BAR .500 x 2.50



Comment: Qty.: 1.4070 f(s)/Unit Total : 2.8140 f(s)

304 BAR .500 x 2.50

Batch: 11330 13 9-5-11

**CERTIFICATE OF CONFORMITY  
REQUIRED**



2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3901

Dwg Rev: PRE 13 9-5-11

Prog Rev: Lim

2-Deburr if necessary R



(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

13 9-5-11



4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

**ENGINEERING  
APPROVAL**

13 09-09-02



(P70)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-drill holes as per dwg D3901

2-deburr

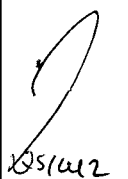
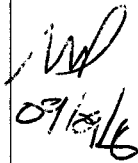


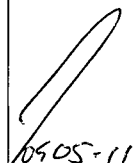


13 9-5-11 X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3901-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 7 Date: 05-05-16

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47816</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0505-11	2.0	1 part is 0.050" thick in the cut out for weld, at the radius location (Fwd). Taper & blow out from the w J. RC: process.		Try part cut as prelim.	 05/05/16	 05-05-16	 05/05-11	 0505-11

NOTE: Date & initial all entries

Date: Friday, 08/05/2009 7:53:12 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 47816

Part Number: D39015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



9-05-14 (2)

**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

PH 09-09-02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B47724

STORE IN ENG'S SHED  
ENG USE ONLY

PH 09-09-02

EL 9-5-14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



INITIAL RECALL

EFFECTIVE 09-05-08

AUTH h

LEASED PH

DATE 09-06-22

MF  
09-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47816
<b>Description:</b> BAR		<b>Part Number:</b> D3901-5
<b>Inspection Dwg:</b> D3901-5 <b>Rev:</b> PRE Lim		Page 1 of 1

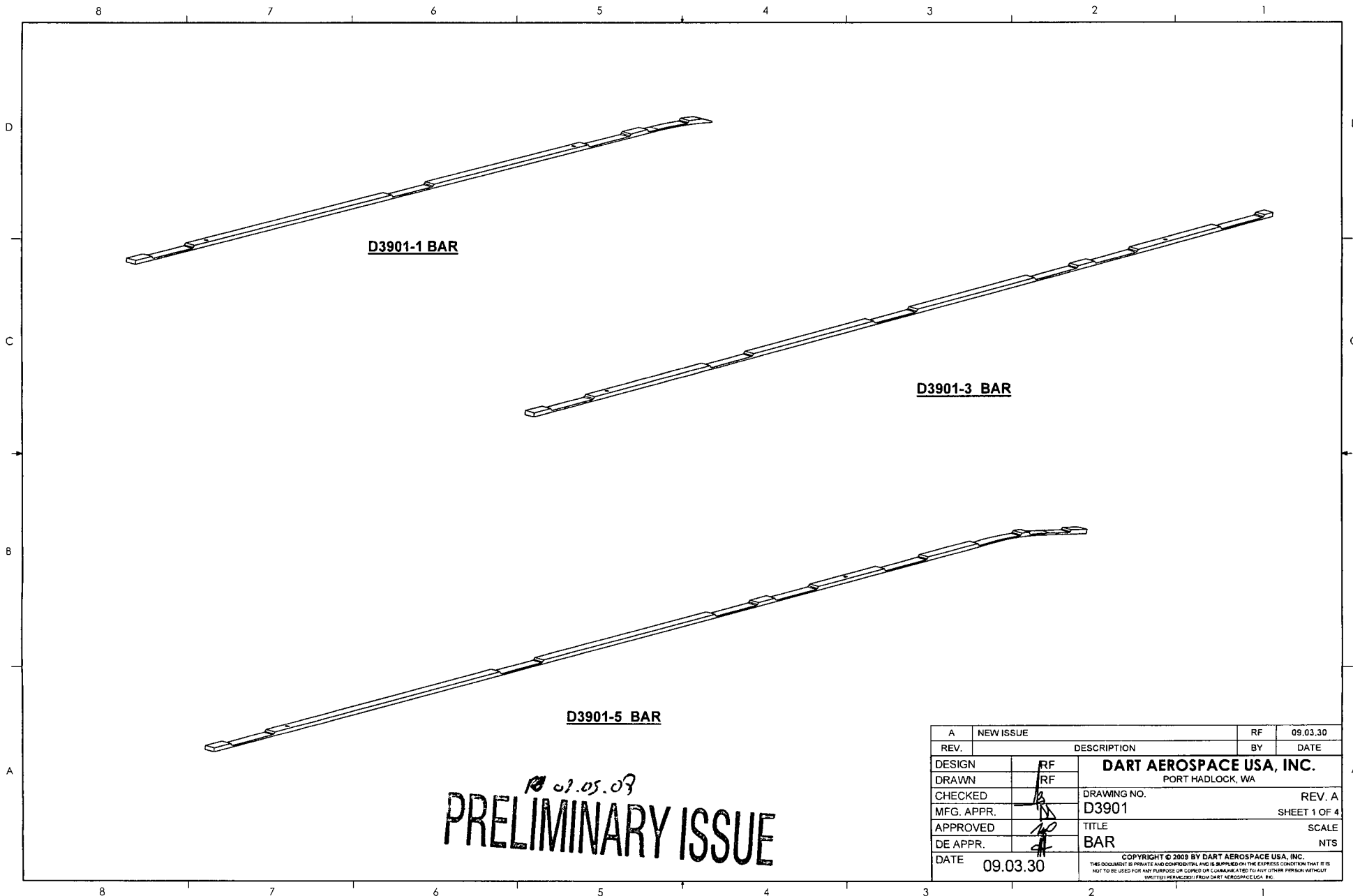
### FIRST ARTICLE INSPECTION CHECKLIST





☒ First Article ☐ Prototype

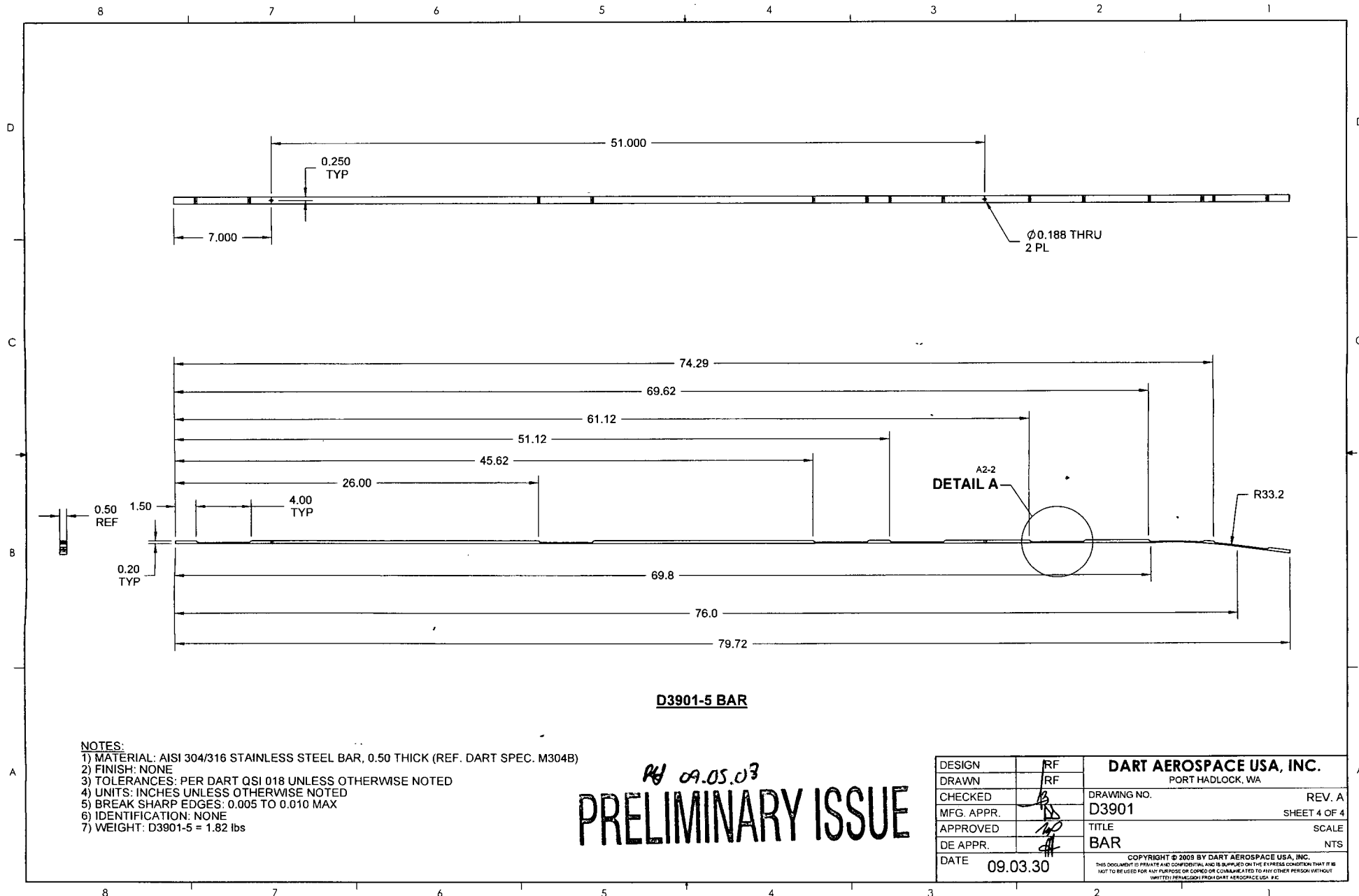
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	±.030	.505	X			
.20	±.030	.202	X			
1.50	±.030	1.50	X			
4.00	±.030	4.00	X			
26.00	±.030	26.00	X			
45.62	±.030	45.62	X			
51.12	±.030	51.12	X			
61.12	±.030	61.12	X			
69.62	±.030	69.62	X			
74.29	±.030	74.29	X			
69.8	±.100	69.8	X			
76.0	±.100	76.0	X			
79.72	±.030	79.72	X			

<b>Measured by:</b> IB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> [Signature]
<b>Date:</b> 9-5-11	<b>Date:</b> 10-05-12	<b>Date:</b> 09-09-02

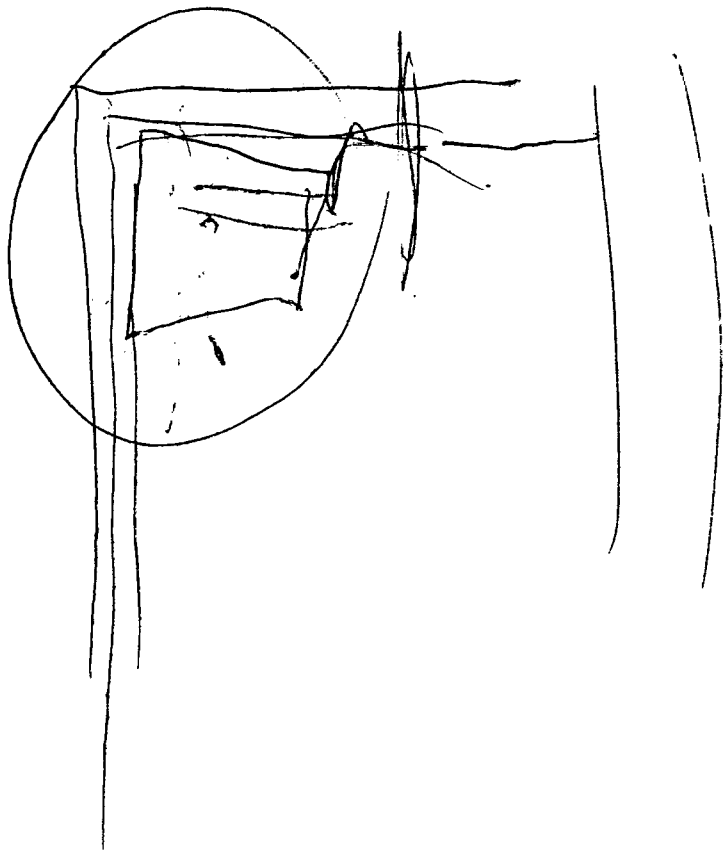
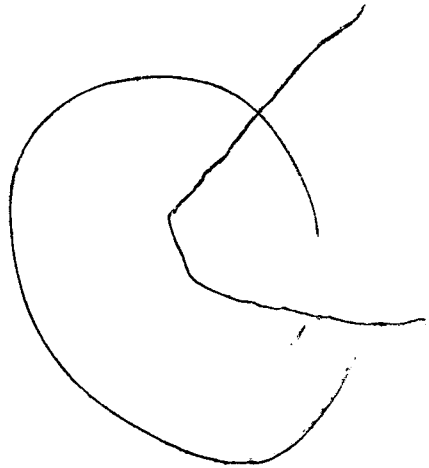
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



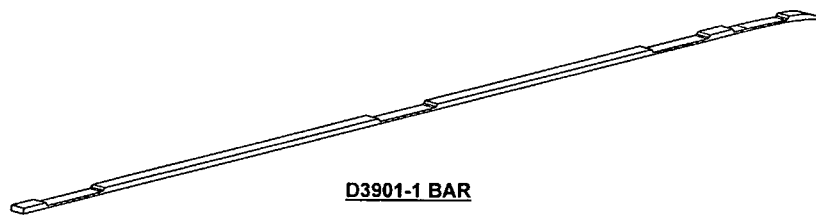
A		NEW ISSUE		RF	09.03.30
REV.		DESCRIPTION		BY	DATE
DESIGN		RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN		RF			
CHECKED			DRAWING NO.	REV. A	
MFG. APPR.			D3901	SHEET 1 OF 4	
APPROVED			TITLE	SCALE	
DE APPR.			BAR	NTS	
DATE		09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		



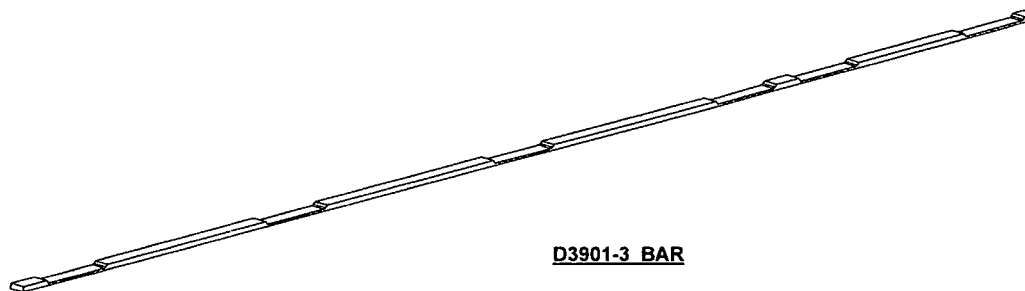
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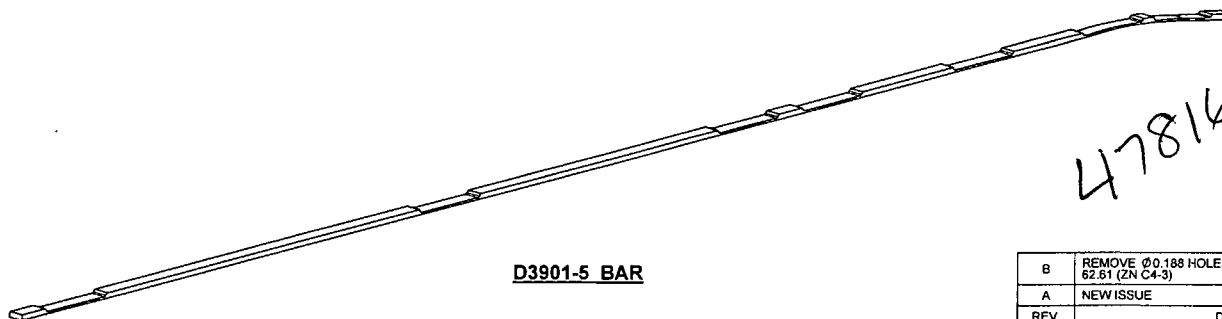




**D3901-1 BAR**



**D3901-3 BAR**

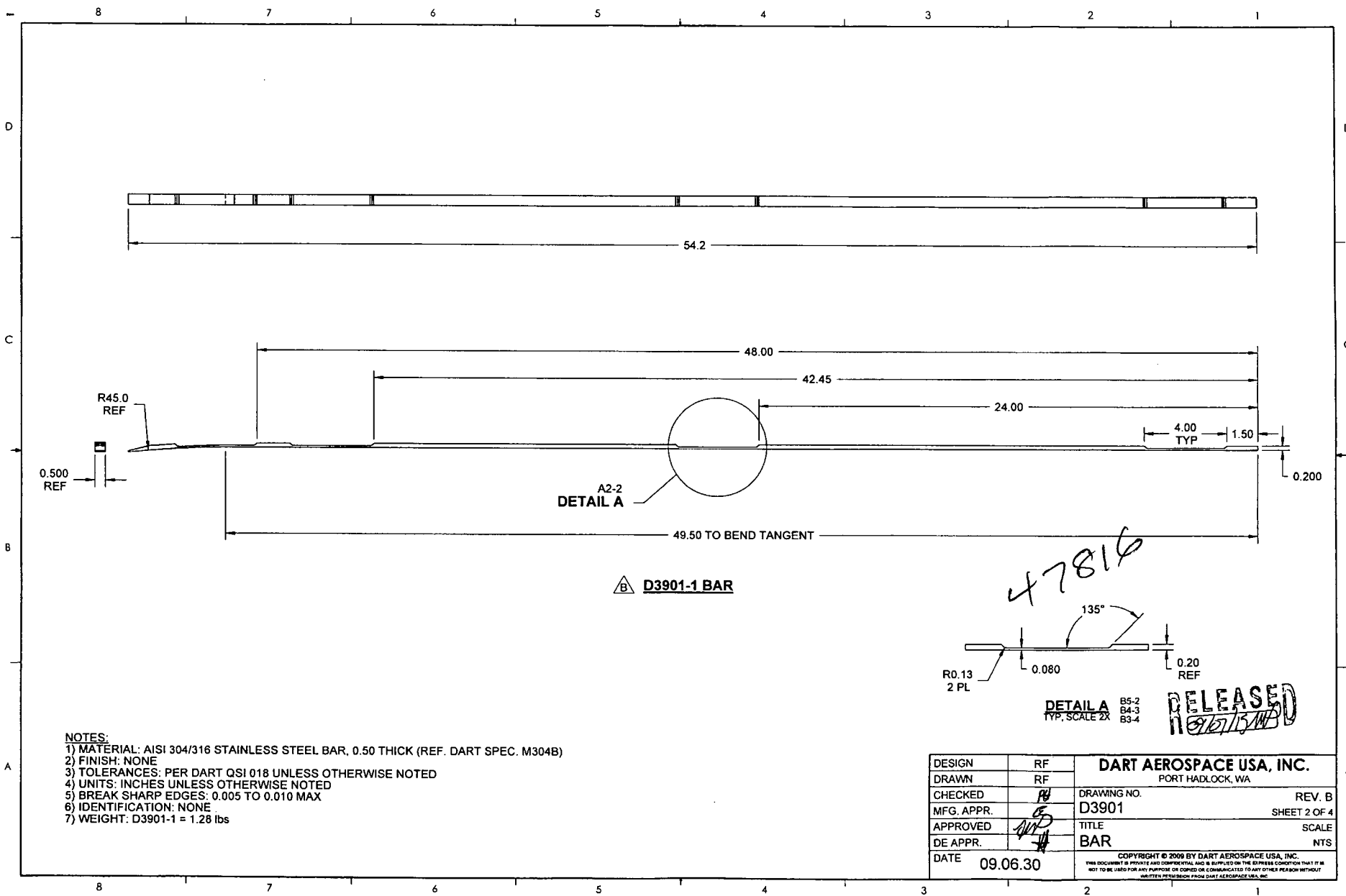


**D3901-5 BAR**

47816

RELEASED  
09/07/13 MJP

B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5: 62.12 WAS 62.51 (2N C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3901</b> REV. B SHEET 1 OF 4 TITLE <b>BAR</b> SCALE <b>NTS</b>	
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>E</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: D3901-1 = 1.28 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3901	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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8 7 6 5 4 3 2 1

D

D

C

C

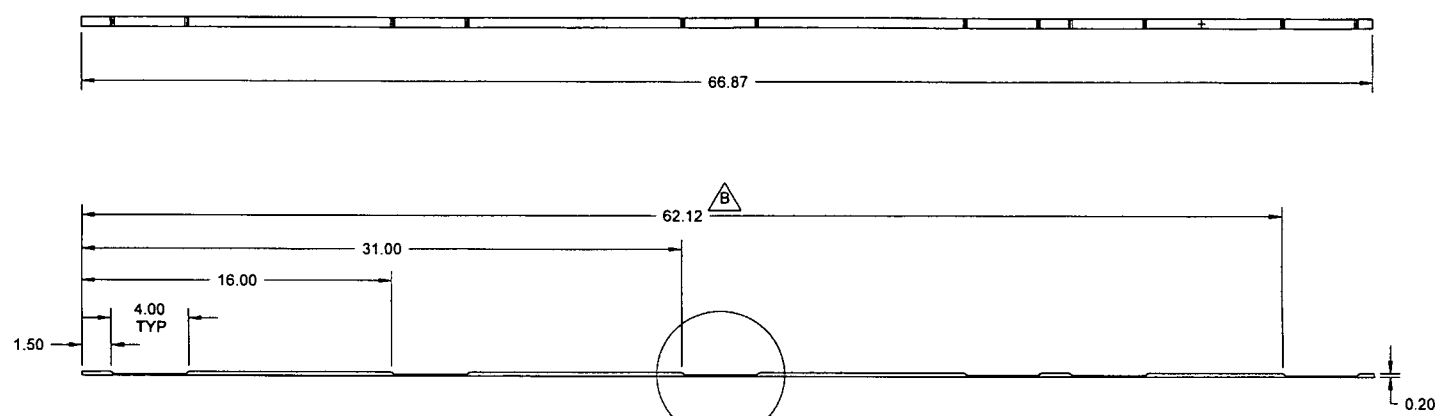
B

B

A

A

0.50  
REF



**D3901-3 BAR**

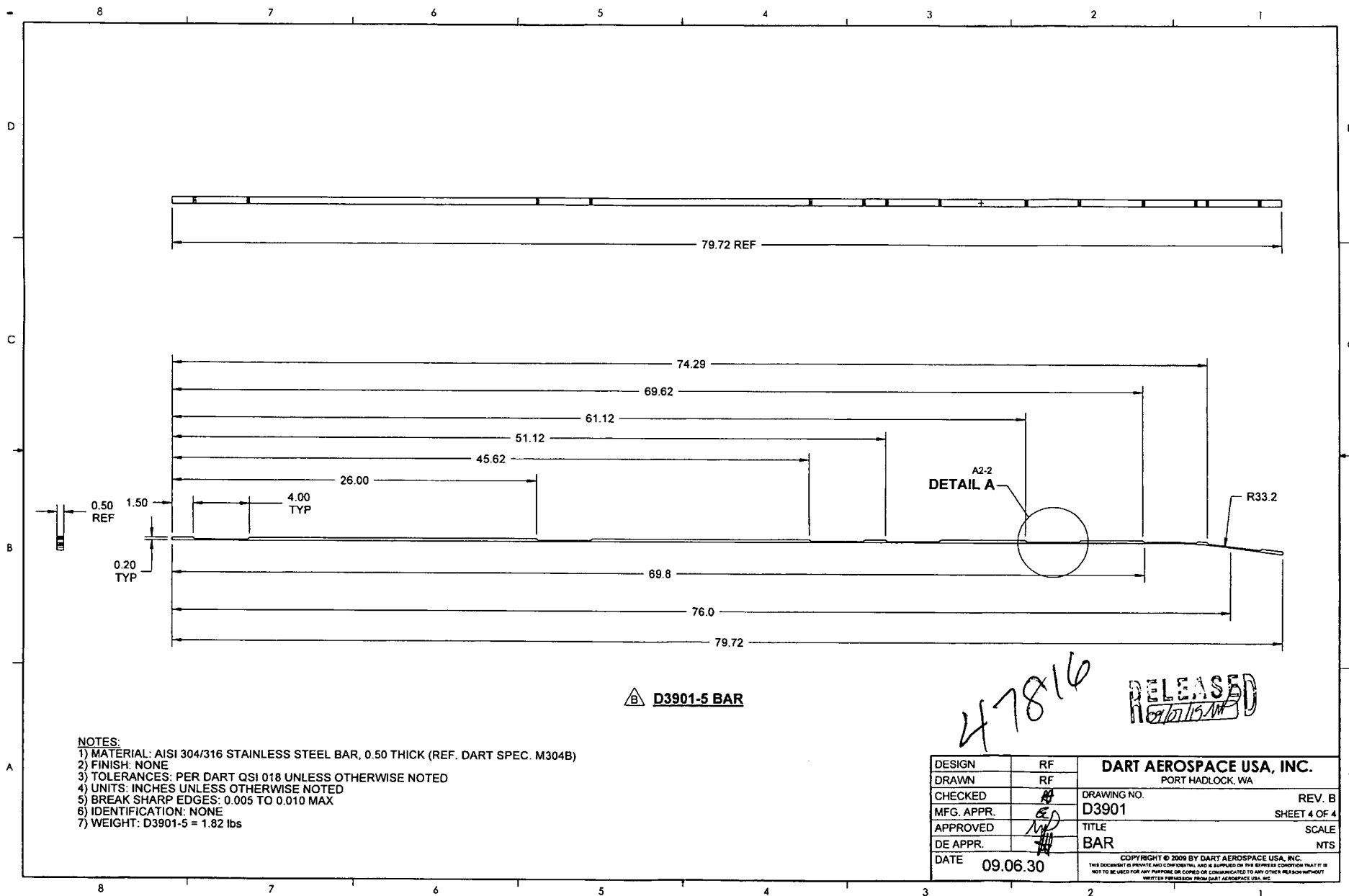
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: D3901-3 = 1.53 lbs

47816

RELEASED  
19/07/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>AB</i>	DRAWING NO. <b>D3901</b>	REV. B
MFG. APPR.	<i>ED</i>	SHEET 3 OF 4	
APPROVED	<i>IN</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	<b>BAR</b>	NTS
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8 7 6 5 4 3 2 1



**D3901-5 BAR**

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3901</b>	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE <b>BAR</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NTS
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